

NCR-19-7687



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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same base

DTAI-1038-043
Job Sheet 196933



Part No: DTAI-1038-043

Job Qty: 1 pcs

Part Name: Lower Cutter Installation, Long



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: SOLD

Description:

Note: DTAI-1038-043 REV.A6 IPP REV.A 17.09.12 NEW ISSUE DD VERF:JFS IPP REV.B 17.11.23 AS PER DWG
REVA.6 DD VERF:JFS

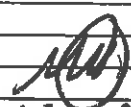
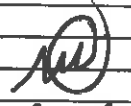
Ship Via:

B/I of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	7/5/19		0.00	25.00	Small Fab - 1		AUG 09 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
105	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10		AUG 09 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
110	Packaging 1-1 - Pick Kit - B4B	1 pcs	7/5/19		0.00	0.00	Packaging 1 - 1 - B4B		
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		
							Packaging 1 - 4 - B4B		
							Packaging 1 - 5 - B4B		
							Packaging 1 - 6 - B4B		

Plex 6/25/19 3:58 PM Dart.Guerin.Kimberley

				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	Max B.
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
120 QC 4	1 pcs	7/5/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	 8/28/2019
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
140 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	 8/28/2019
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
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				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
145 DC - 1 - B4B	1 pcs	7/5/19	0.00 0.00	DC - 1 - B4B	AUG 29 2019
				DC - 2 - B4B	
150 QC 21 - SA	1 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	AUG 29 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Small Fab - ASSEMBLE AS PER DWG AND APPLY RTV TO ALL FAYING SURFACES RTV 598
 Descriptions: BATCH: S173363 exp 12/20

105 - QC5- Inspect part completeness to step on W/O

110 - Pick Kit

120 - QC4- 100% Inspect kits for completeness

140 - Identify and pack for shipping as per PPP DTAI-1038-043 Location: _____ PPP Rev: _____

145 - Document Control - Photocopy bluefile and create labels as per PPP DTAI-1038-043 Chg 001

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5501-041	Body, Lower Cutter Assembly, Long	2 1/1 pcs (1 ea)	100-Small Fab - 1	S2013-46
D5506-3	Base, Lower Cutter, Long	2 1/1 pcs (1 ea) ✓	100-Small Fab - 1	S197504 ✓
MS21042L4	Nut	6 3/3 Ea (3 ea) ✓	100-Small Fab - 1	S198112 ✓
MS27039-4-20	Screw	6 3/3 Ea (3 ea) ✓	100-Small Fab - 1	S180206 ✓
NAS1149D0432J	Washer	12 6/6 Ea (6 ea) ✓	100-Small Fab - 1	S184981 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D5501-041	1	0	0
	D5506-3	1	0	0
	MS21042L4	3	2,410	0
	MS27039-4-20	3	78	0
	NAS1149D0432J	6	200	0

Part Specifications

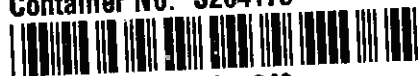
Specifications could not be found.

Plex 6/25/19 3:56 PM Dart.Guerin.Kimberley

Master Unit No 011098



Container No: S204173



Part: DTAI-1038-043

Job No: 196933

Serial No/Batch: S204173

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/09/18

Entered: 112 Date: Nov 1/19



NCR No. 19-7687 WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>196933</u> Part No. <u>DTAR-1038-043</u> <u>BBU.A</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☒ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date: <u>AUG 23/19</u>		Sequence #:		QTY Affected: <u>2</u>		MRB (QSI042) <u>Moe</u>																													
Description Work Order Deviation				Disposition		AUG 23/19 Completed By																													
Eng. Note 9: BA 7B-SH2, DWG D5506 Rev. A Reqt: Ream to final size after finishing φ0.257 Touch up bare metal with electrocatalytic conductive chemical film material (Alodine 600) per MIL-DTL-5541. Actual: no evidence ^{Record} to demonstrate its being done in operations as needed REF: D5506-3 196676				QTY(1) φ0.257 HOLE (CLASS 9) HAS BEEN REAMED TO φ0.258 AFTER FINAL ASSY. ALL BARE ALUMINUM HAS BEEN TOUCHED UP WITH ALODINE 600. REASSEMBLED USING ORIGINAL HARDWARE. PROBEAL PR-1764 B/N <u>209467</u> NO DEVIATIONS, REWORK TO DWG		OCT 31 2019																													
						Lead hand / Supervisor																													
						QC / QA Coordinator																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☒ Human Factors ☐		FAULT CATEGORY <table style="width:100%;"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☒ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☒ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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